



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3564-11
Job Sheet 171695



Part No: D3564-11

Job Qty: 11 ea

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/7/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	11 Ea	2/15/18	2/15/18	0.00	0.00	Start Up Waterjet		SC 18/02/08
100	Waterjet	11 pcs	2/15/18	2/15/18	0.00	1.91	Waterjet1		SC 18/02/08
120	QC	11 pcs	2/15/18	2/15/18	0.00	0.00	QC8		38
130	Brake NC	11 pcs	2/15/18	2/15/18	0.38	0.73	Brake NC 1		38 SB
140	QC	11 pcs	2/15/18	2/15/18	0.00	0.00	QC5		38
150	Autoweld 1	11 pcs	2/15/18	2/15/18	0.00	4.67	Automated welding		DYC 9-08 18/02/13
160	QC	11 pcs	2/15/18	2/15/18	0.00	0.00	QC10		38 DAS
170	QC	11 pcs	2/15/18	2/15/18	0.00	0.00	QC5		9-08 38
180	SprayPaint	11 pcs	2/16/18	2/16/18	0.00	1.10	Spray Paint		✓ AS FEB 14 2018
190	QC	11 pcs	2/16/18	2/16/18	0.00	0.00	QC5		38
200	Packaging	11 pcs	2/16/18	2/16/18	0.00	0.00	Packaging3-1 FP002.		BEB 18-02-15
210	QC21-SA	11 Ea	2/16/18	2/16/18	0.00	0.00	QC21		DAS 9-08

Part Op 100 - 1-Cut D3564-1 as per Dwg D3564 Dwg Rev: F Prog Rev: E 2-Deburr if necessary 21 FEB 15 2018
Descriptions: 130 - Form on Brake as per Dwg D3564 using Jigs DT8179
150 - 1- AUTOWELD AS PER DWG AND QSI004 3259 HARDCOAT BATCH: _____
180 - APPLY COATING ON CONCAVE SURFACE AS PER DWG AND QSI005 (SEE NOTE 12 ON DWG)

138741

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	15.5100 sf (1.41 ea)	90-Start up Operation	

5021855

15.51

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	16	75	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	3.227inches ± 0.010	3.237 3.217	3,228	
2	Wearshoe	2.432inches ± 0.010	2.442 2.422	2,432	

DART
AEROSPACE
S040746



Wearplate Aft

PART NO: D3564 – 11

Original Serial #: S040746

Revision:

Operation:

Change No:

Start up Operation 02/08/18

Job No: 171695

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3	Wearshoe	2.500inches ± 0.010	2.510 2.490	2,502
4	Wearshoe	6.000inches ± 0.010	6.010 5.990	6,000
5	Wearshoe	12.104inches ± 0.010	12.114 12.094	12,106
6	Wearshoe	18.000inches ± 0.010	18.010 17.990	18,001
7	Wearshoe	18.000inches ± 0.030	18.030 17.970	18,004
8	Wearshoe	9.000inches ± 0.030	9.030 8.970	9,000
9	Wearshoe	11.500inches ± 0.030	11.530 11.470	11,500
10	Wearshoe	0.300inches ± 0.010	0.310 0.290	0,301
11	Wearshoe	0.300inches ± 0.010	0.310 0.290	0,302
12	Wearshoe	0.188inches + 0.005 - 0.001	0.193 0.187	0,190
13	Wearshoe	0.375inches ± 0.010	0.385 0.365	0,377
14	Wearshoe	0.063inches ± 0.010	0.073 0.053	0,059